

Date: Wednesday, 12/7/2005 3:43:20 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 25156		
Estimate Number	: 10227		
P.O. Number	: N/A	Part Number	: D2151
This Issue	: 12/7/2005	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2151 REV. A
First Issue	: 12/7/2005	Project Number	: N/A
Previous Run	: 24493	Drawing Revision	: A
		Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 12/15/2005
Checked & Approved By	: <u>SEE ABOVE. USER & DATE</u>	Qty:	25 Um: Each
Comment	: Est C 00.10.23 Re-format (mpp 2101) EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.0368 sf(s)/Unit Total : 0.9188 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch:

M19059
M19295

FF 05.12-07

2.0 * SHEAR

SHEAR



Comment: SHEAR

Cut blank: 2.194" x 2.300" +/-0.005"

FF 05-12-07

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA110 and Dwg D2151

Identify as D2151

made by Rand

FF 06.04.10

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N/A

5.0

QC8

SECOND CHECK


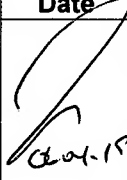
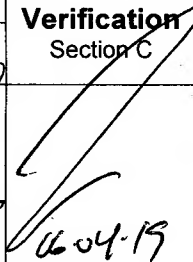




Comment: SECOND CHECK

QC5
for
06.04.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: SP Date: 0604/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0604-15	3	6 parts scrap. - 058 holes off by 1/2 the hole. CMC Part made by hand.		Scrap: destroy no replace.	 06-04-15	 06-04-15		 060415

NOTE: Date & initial all entries

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Drawing Name: DOUBLER

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

FF 06.04.19

19

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

DC 06/04/22

(19)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/04/22

(19)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

16/4/24

(19)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST26

16/4/24

(19)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

DP 06/04/24

(19)

Job Completion



16/04/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

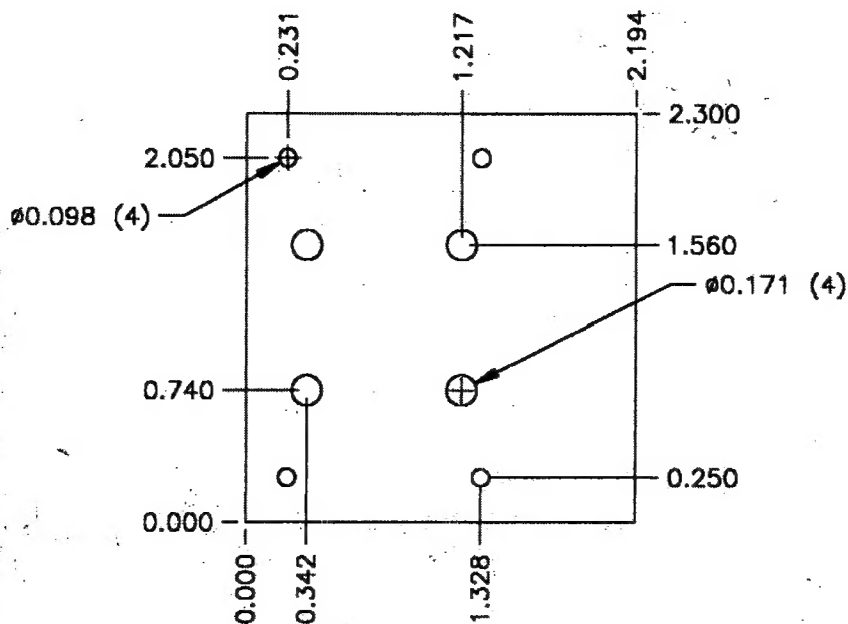
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN B WILLIAMS	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>Bu</i>	APPROVED <i>Bu</i>	DRAWING NO. D2151	REV. A SHEET 1 OF 1
DATE 95:05:01		TITLE PACKER	SCALE 1:1

RELEASED
96/06/13 BU



WORK ORDER
NO. 25156

MATERIAL: 2024-T3, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS